



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D205-634-041
Job Sheet 201220



Part No: D205-634-041

Job Qty: 1 pcs

Part Name: Replacement Skidtube with Standard Wearplates Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/27/19

Job Tracking No:

Due Date: 10/25/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D2580 REV H SHEETS 1,2,3,8 IPP Rev:N 02.08.28 FP was QC5 in Step 27; Added QC5 to Step 30 KJ IPP Rev P 10.02.19 per PAR09-043 EC verified by:DD IPP Rev. O 06.02.28 Added paperwork EC IPP Rev:P 07-07-09 SS Wearplates & Gaskets JLM IPP Rev:Q 10.12.01 as per chg003 DD ver:EC IPP REV:R 12.01.23 AS PER ECN11-684 VERF:EC IPP REV:S 17.12.08 REMOVE GASKET AS PER INTUITIVE INFO DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard	Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Lead Time	
110	Skidtubes - Bend - 1	1 pcs		10/25/19	0.00	0.65	Skidtubes - Bend	MAG
120	Skidtubes - 2 - B4B	1 pcs		10/25/19	0.00	2.89	Skidtubes - 1 - B4B	
							Skidtubes - 2 - B4B	
							Skidtubes - 3 - B4B	MAG
							Skidtubes - 4 - B4B	
							Skidtubes - 5 - B4B	
							Skidtubes - 6 - B4B	
							Skidtubes - 7 - B4B	
130	QC 5	1 pcs		10/25/19	0.00	0.00	QC 5 - 10	
							QC 5 - 12	
							QC 5 - 17	
							QC 5 - 18	BE
							QC 5 - 19	
							QC 5 - 22	
							QC 5 - 24	
							QC 5 - 3	
							QC 5 - 43	
							QC 5 - 49	
							QC 5 - 51	
							QC 5 - 58	
							QC 5 - 68	
							QC 5 - 9	
							QC 5 - 50	
							QC 5 - 30	
							QC 5 - 40	
							QC 5 - 61	
							QC 5 - 81	



Container No: S227965



Part: D205-634-041

Job No: 201220

Serial No/Batch: S227965

Revision: H

Inspector:

Exp Date:

Instructions: TC STC SH96-88 Issue 3 FAA-STD SR005631

Dart Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

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140 Skidtubes - 3 - B4B	1 pcs	10/25/19	0.00 3.00	Skidtubes - 1 - B4B	00
				Skidtubes - 2 - B4B	
				Skidtubes - 3 - B4B	
				Skidtubes - 4 - B4B	
				Skidtubes - 5 - B4B	BE
				Skidtubes - 6 - B4B	
				Skidtubes - 7 - B4B	
150 QC 10	1 pcs	10/25/19	0.00 0.00	QC 10 - 10	DAS 68 9-89 NOV 14 2019
				QC 10 - 18	
				QC 10 - 24	
				QC 10 - 43	
				QC 10 - 50	
				QC 10 - 58	
				QC 10 - 9	
160 QC 5	1 pcs	10/25/19	0.00 0.00	QC 5 - 10	DAS 68 9-89 NOV 14 2019
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
170 Handfinish - 1-1 Chemical-B4B	1 pcs	10/25/19	0.00 1.31	Handfinish - 1 - 1 - B4B	BEB 19-11-20
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 -	

						B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	
180	Powdercoat - 1 White Gl(A)-B4B	1 pcs	10/25/19	0.00	0.34	Powdercoat - 1 - B4B	
						Powdercoat - 2 - B4B	
						Powdercoat - 3 - B4B	BK 19-11-21.
						Powdercoat - 4 - B4B	
190	QC 3	1 pcs	10/25/19	0.00	0.00	QC 3 - 10	
						QC 3 - 13	
						QC 3 - 15	ML 19-11-22
						QC 3 - 17	
						QC 3 - 18	
						QC 3 - 2	
						QC 3 - 28	
						QC 3 - 3	
						QC 3 - 30	
						QC 3 - 34	
						QC 3 - 36	
						QC 3 - 41	
						QC 3 - 51	
						QC 3 - 58	
						QC 3 - 59	
						QC 3 - 68	
						QC 3 - 9	
						QC 3 - 40	
						QC 3 - 19	
						QC 3 - 43	
						QC 3 - 24	
						QC 3 - 61	
						QC 3 - 81	
200	Handfinish - 4-1-Assembly-B4B	1 pcs	10/25/19	0.00	1.00	Handfinish - 4 - 1 - B4B	ML 19-11-25
						Handfinish - 4 - 10 - B4B	
						Handfinish - 4 - 11 - B4B	
						Handfinish - 4 - 12 - B4B	
						Handfinish - 4 - 13 - B4B	
						Handfinish - 4 - 14 - B4B	
						Handfinish - 4 - 15 - B4B	
						Handfinish - 4 - 2 - B4B	
						Handfinish - 4 - 3 - B4B	
						Handfinish - 4 - 4 - B4B	

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DAS
15
9-89

210 QC 5	1 pcs	10/25/19	0.00 0.00	Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
				QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
220 Packaging 3-1 - Stock - B4B	1 pcs	10/25/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	

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11/28/11/10

				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
225 DC - 1 - B4B	1 pcs	10/25/19	0.00 0.00	DC - 1 - B4B	DAS NOV 28 2019
				DC - 2 - B4B	21
230 QC 21 - FG	1 pcs	10/25/19	0.00 0.00	QC 21 - FG - 21	8-20
				QC 21 - FG - 70	DAS NOV 28 2019
				QC 21 - FG - 53	21

Part Op 110 - Skidtubes - 1-Bend as per program D2580.C on CNC Bender and Folio 16 2-Cut tubes as per Dwg. D2580 3- scribe
Descriptions: batch# in aft end of tube

120 - Skidtubes - 1- Deburr ends and remove bending marks 2- Prepare tube for welding as per QSI 004

130 - QC5- Inspect part completeness to step on W/O

140 - Skidtubes 1-Weld step D2576 as per Dwg. D2580 and QSI 004 2-Grind welds on step as per Dwg D2580 3- Insert D4202-1 spacer, swage as per QSI002 and trim/ grind flush per QSI002 and dwg. Hold x-bolt with DT9701 Use tube expander 1/2 x17G to start expansion and finish with 1/2 x 18G to achieve dwg dimension. 4-Drill holes for wearplates using DT 8217 & DT8937, 7.40" from most fwd saddle holes (ref only) Open holes to 19/64", adjust stopper not to hit web. Deburr 5-Drill pilot holes for aft cap using DT 8215 Open holes to 0.208". Deburr 6-Drill pilot holes for Tow ring using DT8091, open to .640" and Deburr

150 - QC10- Inspect visual per QSI004- ground welds

160 - QC5- Inspect part completeness to step on W/O

170 - Chemical Conversion Coat per QSI005 4.1 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch and leave fwd cap out of solution.

180 - White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum START TIME: 1:20.5 OVEN TEMPERATURE: 320°

FINISH TIME: 1:23 11/21/86

190 - QC3- Inspect Part Finish

200 - Assemble as per dwg - 1-Install inserts & wearplates as per Dwg. D2580. Use a drop of Sikaflex on insert holes before installing wearplates A/R Sikaflex-291 520062 Sikaflex expire date: 20-7-2 2-Coat D2594-3 O' rings with Petroleum Jelly and install on D2594-1 plugs as per Dwg D2580 3-Inspect for foreign object per QSI 024 4-Install 2855 Aft Cap as per Dwg D2580 and seal Fwd Step & Aft Cap with Sikaflex. Clean excess adhesive A/R Sikaflex-291 520062 Sikaflex expire date: 20-7-2 5-Wing Walk as per Dwg D2580 and QSI 005 4.4 Batch: 5229643

210 - QC5- Inspect part completeness to step on W/O - Inspect Aft Cap, Fwd Step and Wing Walk of work to Current Step Inspect for Foreign objects per QSI 024

220 - Identify and pack for shipping as per PPPD205-634-041 Location: _____ PPP Rev: _____

225 - Document Control - Photocopy D205-634 bluefile & type labels per PPP D205-634-041 CHG006

230 - QC21- Final Inspection - Work Order Release

Job BOM

013102

Part / Item	Component Name	Quantity	Operation	Container
D2580-1	205 Bent Tube	1 pcs (1 ea)	110-Skidtubes - Bend - 1	
D2576-3	Step (Machining Detail)	1 pcs (1 ea)	140-Skidtubes - 3 - B4B	5177095
D4202-1	Spacer	20 pcs (20 ea)	140-Skidtubes - 3 - B4B	5184647
ALS7-1032-130	Rivnut	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5209194
AN3-5A	Bolt	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5216385
AN3C4A	Bolt	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5217813
D2594-1	Plug	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5229067
D2594-3	O-Ring	16 pcs (16 ea)	200-Handfinish - 4-1-Assembly-B4B	5045947
D2855	Cap	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5194524
D3564-11	Wearplate Aft	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5222906
D3564-13	Wearpad Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5207800
D3564-5	Wearplate Center	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208675
D3564-9	Wearplate Fwd	1 pcs (1 ea)	200-Handfinish - 4-1-Assembly-B4B	5208909
NAS1149C0332R	Washer (AN960C10L)	50 Ea (50 ea)	200-Handfinish - 4-1-Assembly-B4B	5225629
NAS1149D0332J	Washer	2 Ea (2 ea)	200-Handfinish - 4-1-Assembly-B4B	5178379

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Skidtubes - Bend - 1	D2580-1	1	11	0
140-Skidtubes - 3 - B4B	D2576-3	1	70	0
	D4202-1	20	700	0
200-Handfinish - 4-1-Assembly-B4B	ALS7-1032-130	50	1,502	0
	AN3-5A	2	272	0
	AN3C4A	50	484	0
	D2594-1	16	59	0
	D2594-3	16	466	0
	D2855	1	78	0
	D3564-11	1	9	0
	D3564-13	1	26	0
	D3564-5	1	19	0
	D3564-9	1	18	0
	NAS1149C0332R	50	2,501	0
	NAS1149D0332J	2	1,766	0
Part Specifications				
Specifications could not be found.				

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ITEM	QTY -041	QTY -045	QTY -047	QTY -048	PART NUMBER	DESCRIPTION
1	X				D2680-041	SKIDTUBE ASSEMBLY
2		X			D2680-045	SKIDTUBE ASSEMBLY
3			X		D2680-047	SKIDTUBE ASSEMBLY
4				X	D2680-048	SKIDTUBE ASSEMBLY
20	1	1	1	1	D2680-1-100	ENTRUSION
21			10	10	D2670	BUSHING
22	1	1	1	1	D2678-3	STEP
23		4			D2679	SPACER
24	10	10	8	8	D2684-1	PLUG
25	10	10	8	8	D2684-3	O-RING
26	1	1	1	1	D2688	200 WEB
27	1	1	1	1	D2685	AFT CAP
28	1	1			D2684-5	WEARSHOE
29	1	1			D2684-9	WEARSHOE
30	1	1			D2684-11	WEARSHOE
31	1	1			D2684-13	WEARSHOE
32	20	20	24	24	D4205-1	SPACER
33			1	1	D4009-041	WEARPLATE ASSEMBLY
34			1	1	D4009-043	WEARPLATE ASSEMBLY
35				1	D5001-1	PHD WEARPLATE
36				1	D5001-3	AFT WEARPLATE
50	50	50			AL37-1032-130 or AN37-1032-130 or AN34-1032-130 or MIL-S-1032-130	INSERT
61	50	50			AN30A	BOLT
62	2	2	2	2	AN34A	BOLT
63			8	8	AN4-10A	BOLT
64	50	50			AN31140C0032R	WASHER (AN300C10L)
65	2	2	2	2	AN31140C0032J	WASHER (AN300C10L)
66			8	8	AN31140C0032J	NUT (OR M321042L)

GENERAL NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION PER DART Q88 4.1 PRIOR TO INSERTING D2684 WEB
POWDER COAT (441-047-048) GLOSS WHITE (REF 4.3.4.1) PER DART Q88 4.3
BLACK ANTI-SEED PAINT AS INDICATED PER DART Q88 4.4.
TOLERANCES ARE PER DART Q88 018 UNLESS OTHERWISE NOTED.
- 3) LIMITS: INCHES UNLESS OTHERWISE NOTED.
- 4) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 5) IDENTIFICATION: NONE
- 6) WEIGHT: D2680-041 = 35.7 lbs
D2680-045 = 33.7 lbs
D2680-047 = 45.1 lbs
D2680-048 = 32.0 lbs
- 7) WELDING PER DART Q88 004.
- 8) INSERT D2688 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO
OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE PER DART Q88 015 BEFORE
BENDING. ENSURE HOLES LINE-UP.
- 9) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM CENTERLINE RADIUS OF 60 AND
ENDING WITH A MINIMUM RADIUS OF 30. A MAXIMUM REDUCTION OF 0.200 IN DIAMETER IS
ALLOWABLE IN THE BENT PORTION OF THE TUBE.
- 10) USE DART DRILL TEMPLATE DTR217 & DTR607 ONLY FOR D2680-041/045 TO LOCATE AND DRILL
60.297 HOLES FOR WEARSHOE INSERTS. INSTALL AL37-1032-130 PER SECTIONS B-B AND F-F (60
PLACES) AFTER FINISH. INSTALL AN30A BOLTS AND AN31140C0032R WASHERS WITH
SIKAFLEX-241-391.
- 11) INSERT D2684-1 PLUG CW D2684-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER
FINISH (16 PLACES FOR D2680-041/045 AND 8 PLACES FOR D2680-047/048)
- 12) IT IS ACCEPTABLE TO GRIND A BEVEL IN THE D2688 AFT CAP TO PREVENT INTERFERENCE WITH
THE SPACER AT THIS LOCATION

H	SHEET 1: PL DELETE D2686-11/0-13 GASKETS, WEIGHTS UPDATED ACCORDINGLY. SHEETS 2 & 4 PICTORIAL UPDATE FOR REMOVAL OF GASKETS	SAD	17.06.09
G	ADDED -048 -047 WEIGHT UPDATED PER D81 0028	AJS	14.04.09
F	INCORPORATE DED D2680-E-1 PER PARTS-216	DC	13.02.20
E	ADD D2680-047 (2N 04-7) AND D2680-7 (2N 03-3) INCLUDED DED D2680-D-1; REFORMATTED DRAWING TO CURRENT STANDARDS; DTR217 & DTR607 WAS D2687-305 (2N 04-1)	RF	11.06.21
D	CHANGE TO SS WEARPLATES AND GASKETS,	PH	07.04.05
C	INCLUDE DED 0124/0105	CP	06.02.28
B	REDRAWN, INCLUDED DED 0004/0007	D8	06.12.02
A	AS MANUFACTURED	D8	06.02.16
REV.	NEW ISSUE	D8	
DESIGN	DS	BY	DATE
DRAWN	SAD		
CHECKED	10/2/09		
MPG APPR	D2680		
APPROVED			
DE APPR			
DATE	17.06.09		
DART AEROSPACE LTD HARRISBURG, ONTARIO, CANADA			
DRAWING NO. D2680			
REV. H			
SHEET 1 OF 9			
SCALE			
TITLE			
205 SKIDTUBE ASSEMBLY			
NTS			

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ORDER

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2017 JUL 05/1

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5077-501

1909-24



2017 JUL 05 *q*

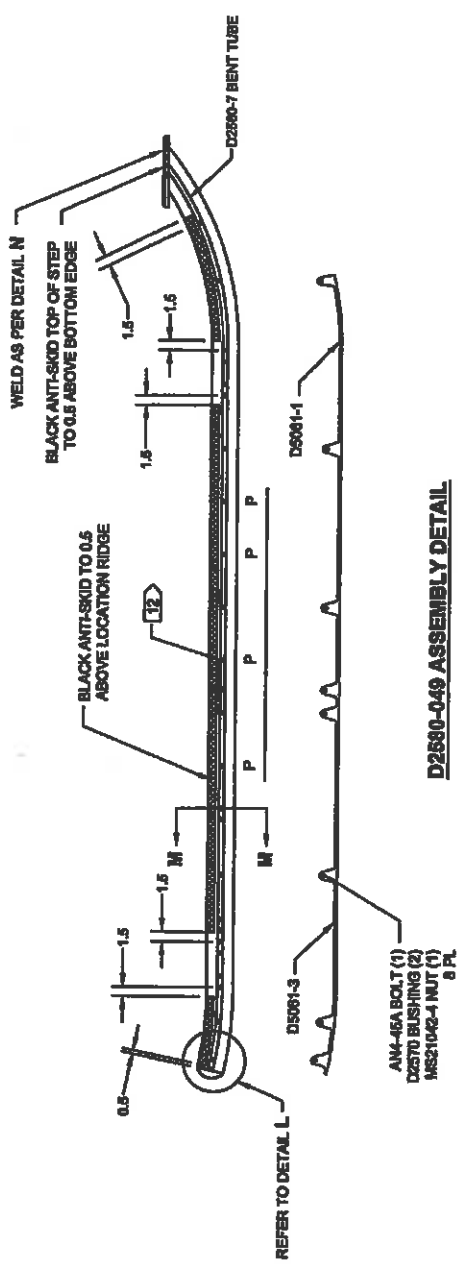
DESIGN	DS	DART AEROSPACE LTD	
DRAWN	SAD	HAMMERSBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2550	SHEET 3 OF 9
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	CONSULT W. H. HART & ASSOCIATES LTD 1700 Macdonald Avenue, Suite 100, Scarborough, Ontario M1V 4A9 Tel: (416) 291-1111 Fax: (416) 291-1112	



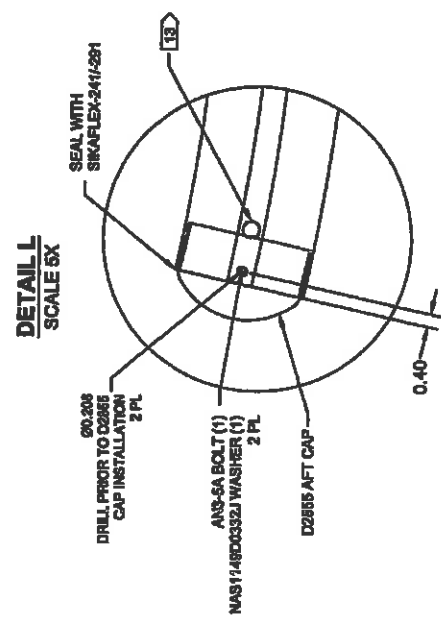
RELEASED
2017 JUL 05 40

DESIGN	DS	DART AEROSPACE LTD HAWKSBURY, ONTARIO, CANADA	
DRAWN	SAD	DRAWING NO.	REV. H
CHECKED	<i>[Signature]</i>	D2580	SHEET 6 OF 9
MFG. APPR.	APPROVED	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	205 SKIDTUBE ASSEMBLY	NTS
DATE	17.06.09	COPYRIGHT © 1989 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS TO BE KEPT IN THE ORIGINAL FILED WITH THE DRAWING. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM.	

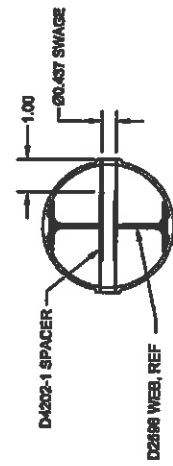
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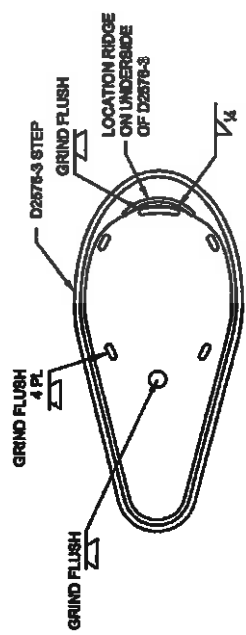
D2580-049 ASSEMBLY DETAIL



SECTION M-M
SCALE 5X



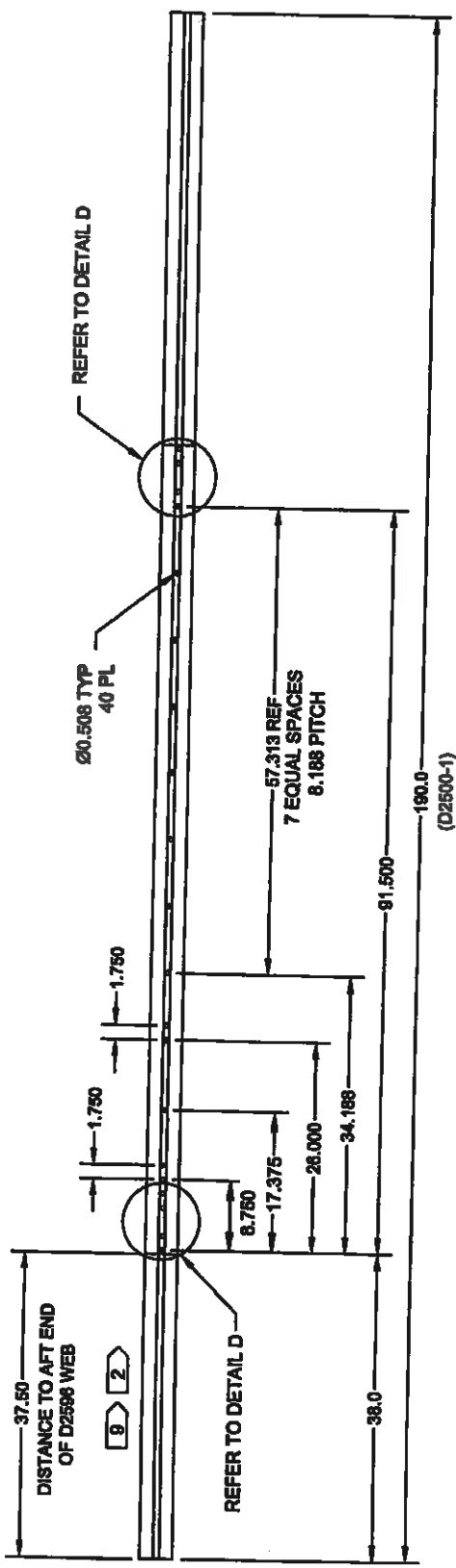
DETAIL N
SCALE 5X



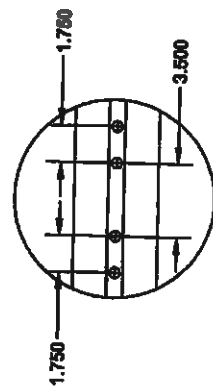
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR 60.608 HOLES ONLY:
1. INSERT D4202-1 SPACER (24 PLACES)
2. SWAGE TO 20.437 X 1.00 DEEP PER CSI 002
3. TRIM GRIND FLUSH PER CSI 002

RELEASED
2017 JUL 05

DESIGN	DS	SAO	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	7/2/8	7/2/8	DRAWING NO. D2580
CHECKED	7/2/8	7/2/8	REV. H SHEET 7 OF 9
MFG. APPR.			SCALE
APPROVED			TITLE 205 SKIDTUBE ASSEMBLY
DE APPR.			NTS
DATE	17.06.09		COORDINATOR: D. BARR, DART AEROSPACE LTD DESIGNER: D. BARR, DART AEROSPACE LTD DRAWN: D. BARR, DART AEROSPACE LTD CHECKED: D. BARR, DART AEROSPACE LTD APPROVED: D. BARR, DART AEROSPACE LTD



D2590-101 TUBE



DESIGN	OS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	SAD	
CHECKED	REV. H	DRAWING NO. D2590
INFO. APPR.	SHEET 9 OF 9	
APPROVED	TITLE	205 SKIDTUBE ASSEMBLY
DATE	SCALE	NTS
17.06.09		

RELEASED
2017 JUL 05

DETAIL D
SCALE 5X

Date:

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Route update only							
Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition					
				Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			
Root Cause		FAULT CATEGORY					
Operator ☐		Pressure/Forced ☐		Contamination ☐		Positioned Wrong ☐	
Manufacturing Process ☐		Bending ☐		Misaligned/off center ☐		Outside Tolerance ☐	
Equip/Tooling ☐		Crushing ☐		BOM/Route ☐		Drawing ☐	
Handling/Preservation ☐		Cracks ☐		Broken/Damage/Defect ☐		Finish ☐	
Material ☐		Crimp/Kink/Ripple/Wave/Twist ☐		Incomplete/Unclear Instructions ☐		Part Lost/Missing ☐	
Product Improvement ☐		Marks/Chatter ☐		Drill Holes ☐		Misread ☐	
Process Improvement ☐		Mislabeled ☐		Fit/Function ☐			
Human Factors ☐							
		Other/Details:					